

Work Order ID 131459

Thursday, April 09, 2015 11:43:08 AM

131459

RH door

Page 1

Item ID: D4484-044

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Bottom Panel Assembly, RH

Start Date: 4/9/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/22/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: mfDate: 5-4-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4484

C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4484-3F)

Dwg Rev: CProg Rev: C

2-Deburr if necessary

①

DL 15/04/10

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

①

DL 15/04/10

Page 2

APR 22 2015

Work Order ID 131459

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Page 3

Item ID: D4484-044

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Bottom Panel Assembly, RH

Start Date: 4/9/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/22/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00				1	15-4-22		PDEL
160									
HandFinish	Memo	0.00							
Hand Finishing									
165	QC7-Inspect Chemical Conversion Coat	0.00				1			CN/50427
165									
QC	Memo	0.00							
Quality Control									
166		0.00				1			DAS 41 988 15-4-28
166									
SprayPaint	Memo	0.00							
Spray Painting	Prime tempo grey as per dwg (note 2, sheet 2) Batch: 131846								

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

*** 1 ***

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Insp.
Stamp**

0.00

190

Packaging

Memo

0.00

D.3

9-85

APR 30 2015

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MAY 04 2015

MLS

MS-5-1

Picklist Print

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Page 1

Work Order ID: 131459

131459

Parent Item: D4484-044

D4484-044

Parent Item Name: Aft Bottom Panel Assembly, RH

Start Date: 4/9/2015

Required Date: 4/22/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.12.04 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4484-5		Manufactured	No				Each	14.0000		1		15/04/29	DAS 36 9-89
D4484-5									**				
Nutplate Retainer													

Location	Loc Qty	Loc Code
MF	14	
103646	3	
86321	1	
98154	10	

MS20426AD3-4 ¹³ ^{DAS} ³⁶ ⁹⁻⁸⁹
MS20426AD3-4
 RIVET

Purchased No

Location	Loc Qty	Loc Code
CA	12	
125578	12	
GA	3983	
m131697	3983	
MF4	19	
125578	19	
ST313	961	
m127432	961	

MS20426AD4-4 ¹³ ^{DAS} ³⁶ ⁹⁻⁸⁹
MS20426AD4-4
 Rivet

Purchased No

Location	Loc Qty	Loc Code
GA	495	
125445	495	
ST312	204	
125445	204	

M131624
 (2X)

2

Picklist Print

Thursday, April 09, 2015 11:43:07 AM

Page 2

Work Order ID: 131459

131459

Parent Item: D4484-044

D4484-044

Parent Item Name: Aft Bottom Panel Assembly, RH

Start Date: 4/9/2015

Required Date: 4/22/2015

Start Qty: 1.00

Required Qty: 1.00

MS21059L08

Purchased

No

Each

485.0000

1

MS21059L 08

DAS
36
9-86

Nut

Location

Loc Qty

Loc Code

MF4

74

125654

74

ST260a

200

m131697

200

ST302

211

m131317

11

m131624

200

M6061T6S.063

Purchased

No

100

sf

258.9863

0.188

1

M6061T6S 063

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT

59.25

M131653

59.25

MAT021

199.7363

M128941

11.132

M129845

29.7743

M130096

25

M131322

85.83

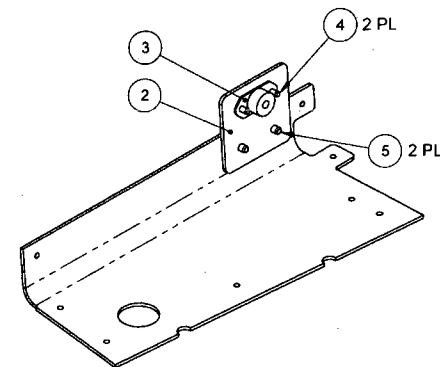
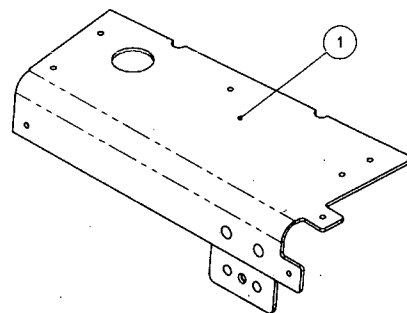
M131383

48

131653

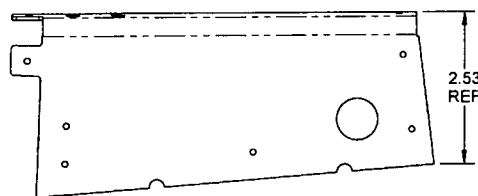
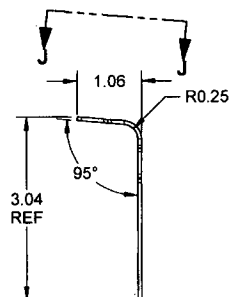
.5

ITEM	QTY	P/N	DESCRIPTION
	X	D4484-044	AFT BOTTOM PANEL ASSY (RH)
1	1	D4484-4	AFT BOTTOM PANEL (RH)
2	1	D4484-5	NUTPLATE RETAINER
3	1	MS21059L08	NUTPLATE
4	2	MS20426AD3-4	RIVET, CSK
5	2	MS20426AD4-4	RIVET, CSK

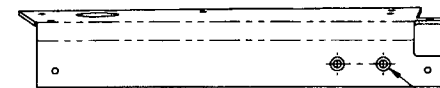


NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.16 lbs

D4484-044 AFT BOTTOM PANEL ASSY (RH)



D4484-4 AFT BOTTOM PANEL (RH)



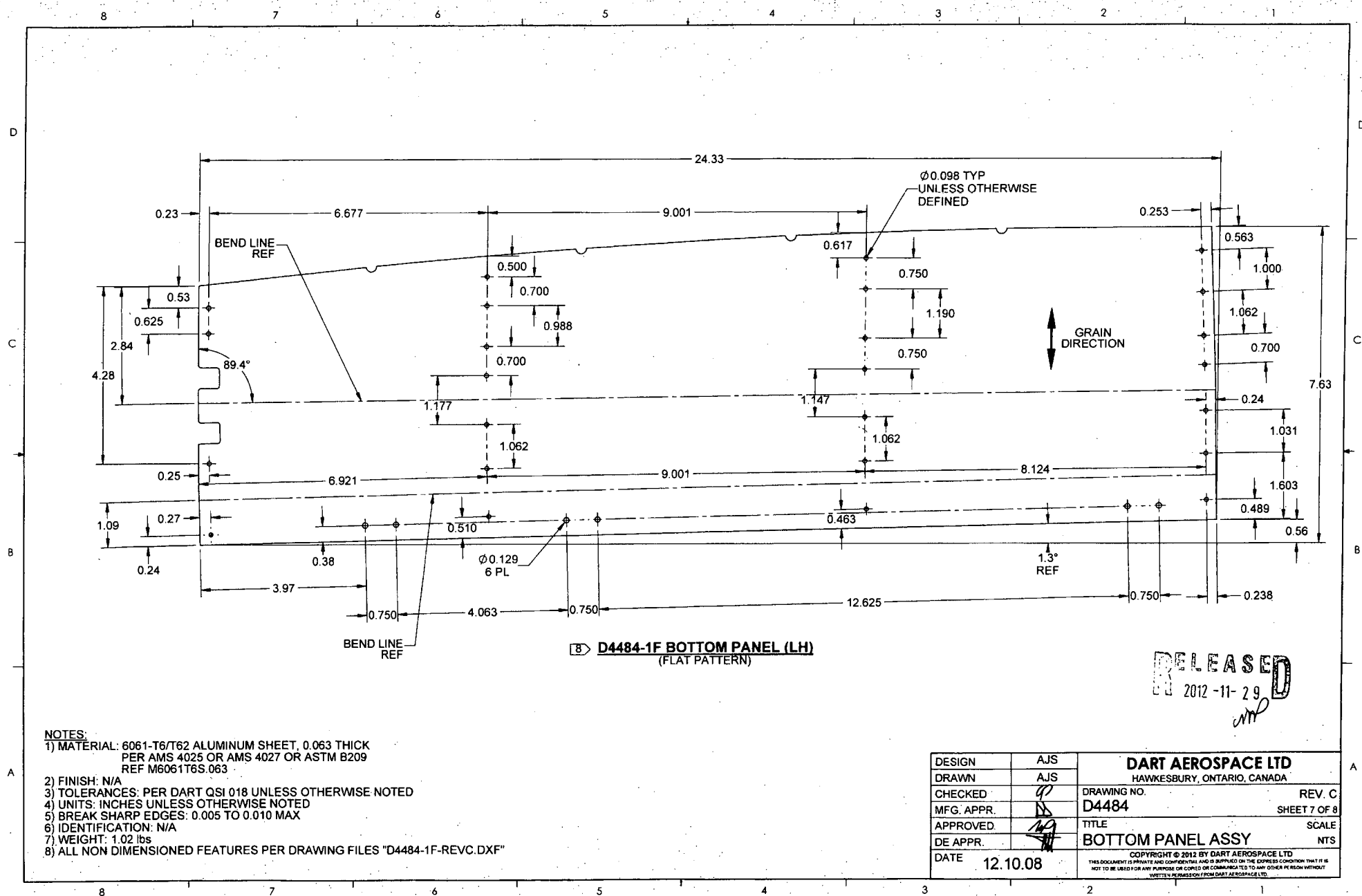
CSK $\phi 0.225 \times 100^\circ$
2 PL

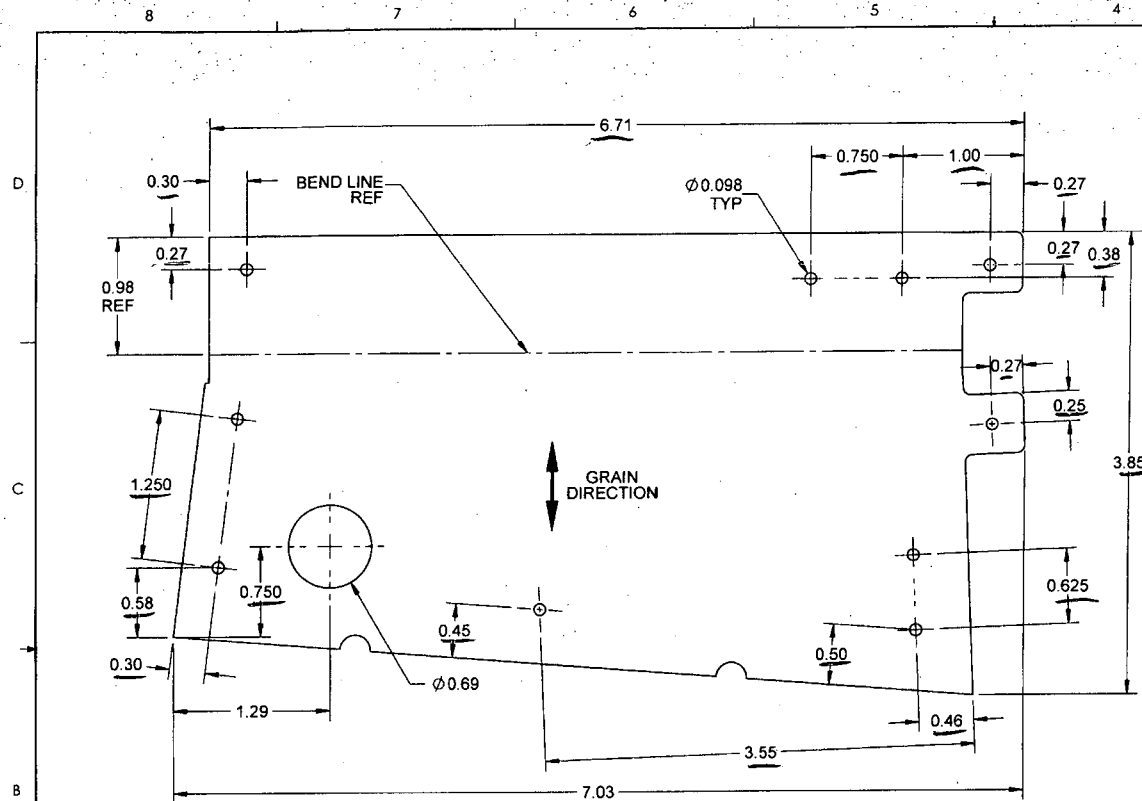
VIEW J-J

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. C
MFG. APPR.	15	D4484	SHEET 6 OF 8
APPROVED	16	TITLE	SCALE
DE APPR.	16	BOTTOM PANEL ASSY	NTS
DATE	12.10.08	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS APPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

mf.
#131459

RELEASED
2012-11-29

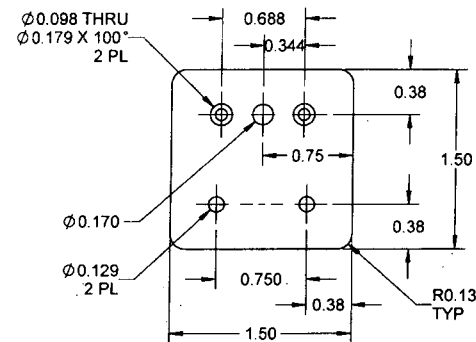




D4484-3F AFT BOTTOM PANEL (LH)
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4484-3F-REVC.DXF"



D4484-5 NUTPLATE RETAINER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

RELEASED
2012-11-29

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. D4484	REV. C
MFG. APPR.	JP	SHEET 8 OF 8	
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BOTTOM PANEL ASSY	NTS
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DART AEROSPACE LTD		Work Order:	131459
Description: Aft Bottom panel		Part Number:	4484-044
Inspection Dwg: 4484 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.27	+/- .030	.271	/		U=DC-01	
.30	+/- .030	.302	/		U=DC-02	
.25	+/- .030	.250	/		Tap	
.46	+/- .030	.461	/			
.50	+/- .030	.506	/			
.58	+/- .030	.582	/			
.45	+/- .030	.451	/			
.38	+/- .030	.374	/			
.625	+/- .010	.624	/			
.750	+/- .010	.747	-			
1.00	+/- .030	1.001	-			
1.250	+/- .010	1.249	/			
3.55	+/- .030	3.551	-			
3.85	+/- .030	3.853	-			
6.74	+/- .030	6.710	/			
7.03	+/- .030	7.03	/			
Ø.095	-.001 +.004	Ø.097	/			
Ø.69	-.001 +.008	Ø.688	/			

DAS

38

9-89

Measured by: <u>DL</u>	Audited by: <u>38</u>	Preliminary Approval:
Date: <u>15/04/10</u>	Date: <u>APR 13 2015</u>	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	